

Date: Tuesday, 7/1/2008 2:33:50 PM
User: Kim Johnston

Process Sheet

ASA P.

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HEAD REST		
Job Number	40186			Part Number	D3303041		
Estimate Number	10738			Drawing Number	D3303 REV.B		
P.O. Number				Project Number	N/A		
This Issue	7/1/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	7/28/2008	Qty:	4
Previous Run	38967			Um:	Each		
Written By	<u>JLM</u>						
Checked & Approved By	<u>JLM</u>						
Comment	Est: B04.10.05 Revised Step 5 with headrest identification K J/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D3303043	Bracket Assembly		
		  Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BRACKET ASSEMBLY Pick: Qty Part Number Description Batch 1 D3303-043 Bracket Assembly B 38969 x 2 40906 2		
2.0	D33051	Cushion		
		  Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) FOAM CUSHION Pick: Qty Part Number Description Batch 1 D3305-1 Cushion B 29945		
3.0	D3306041	Cover Assembly		
		  Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) COVER ASSEMBLY Pick: Qty Part Number Description Batch 1 D3306-041 Cover Assembly B 38970 29945		
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		  Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/8046 adhesive. Identify as D3303-041 <u>M102890</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 40186

Part Number: D3303041

Job Number:



Seq. #: Machine Or Operation:

Description:

A/R 3M 1300/1300L Adhesive Batch: 1102890

SB 08/08/14

2- Cover Head Rest with D3306-041 as per Dwg D3303

FF 08-08-14

5.0 QC5

INSPECT WORK TO CURRENT STEP



10808.14



Comment: INSPECT WORK TO CURRENT STEP

6.0 PACKAGING 1

PACKAGING RESOURCE #1



4x

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: 188

8/8/14

SP

7.0 QC21

FINAL INSPECTION/W/O RELEASE



4

Comment: FINAL INSPECTION/W/O RELEASE

10808/15

Job Completion



U 08.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

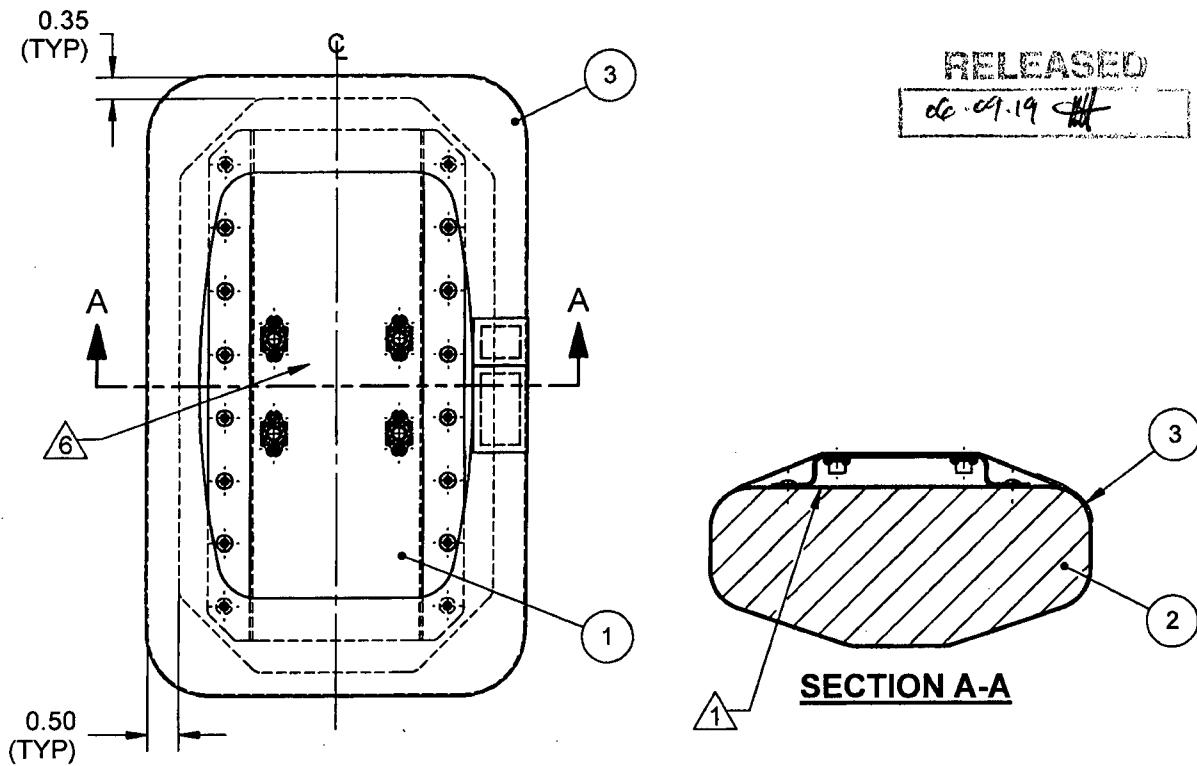
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>BS</i>	DRAWING NO. D3303
DATE 06.08.17		REV. B SHEET 1 OF 4
		TITLE HEAD REST
DATE 04.08.18	SCALE 1:3	
REV A	DATE 06.08.17	DESCRIPTION NEW ISSUE
REV B		UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. *40186*

NOTES:

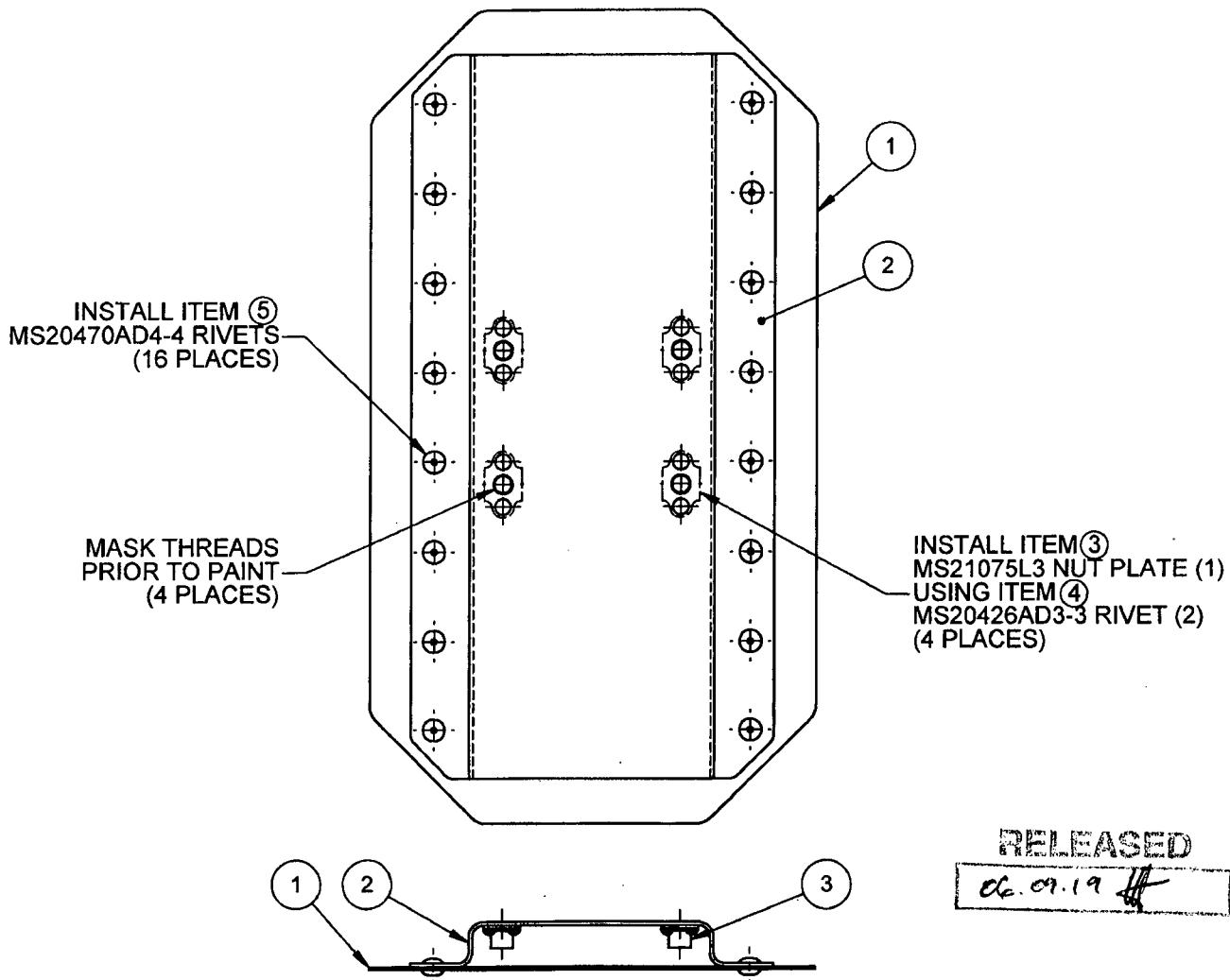
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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NO. *40186*

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DESIGN <i>RF</i>	DRAWN BY <i>JS</i>
CHECKED <i>PH</i>	APPROVED <i>JH</i>
DATE 06.08.17	

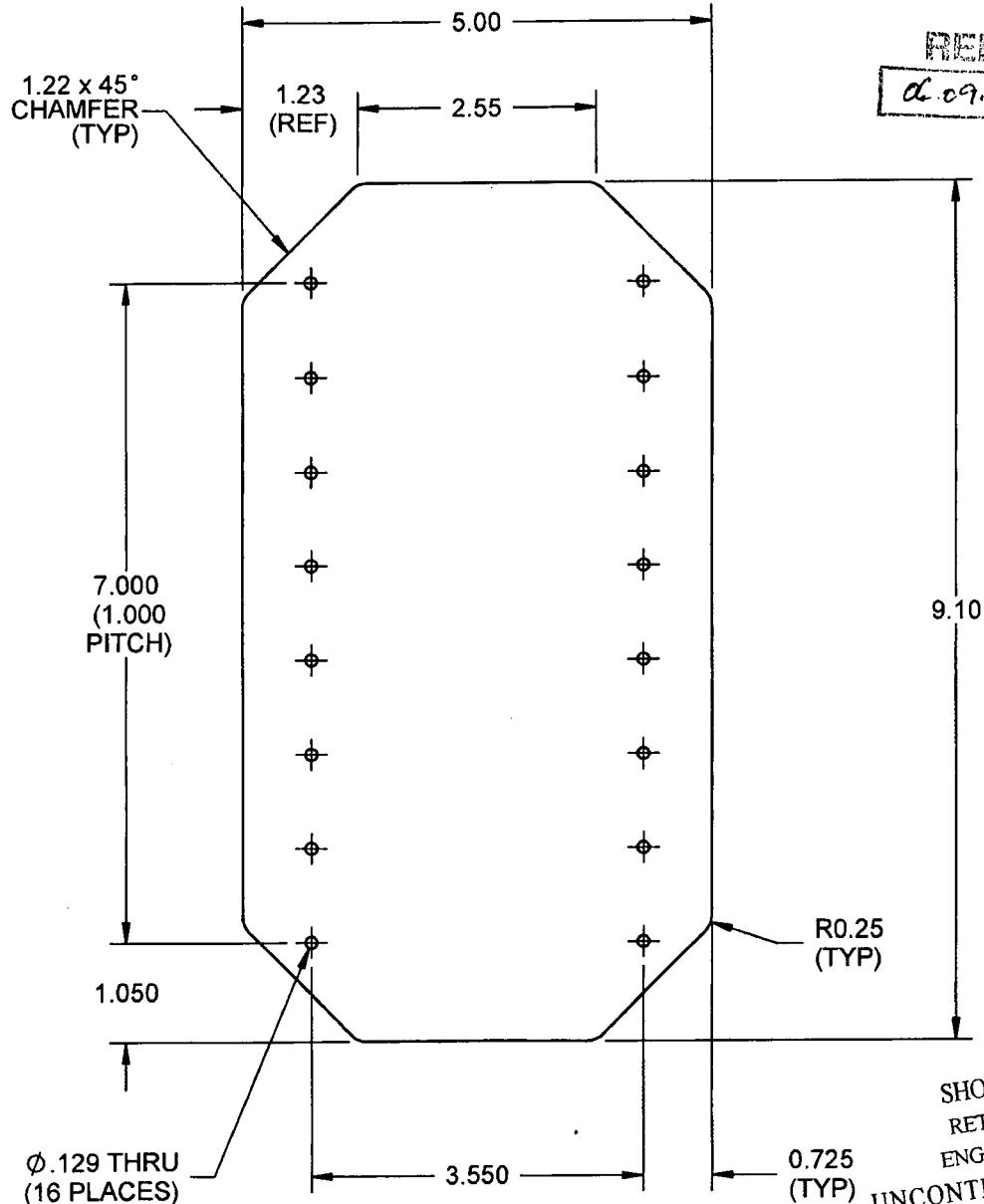
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D3303

REV. B

SHEET 3 OF 4

SCALE

1:2

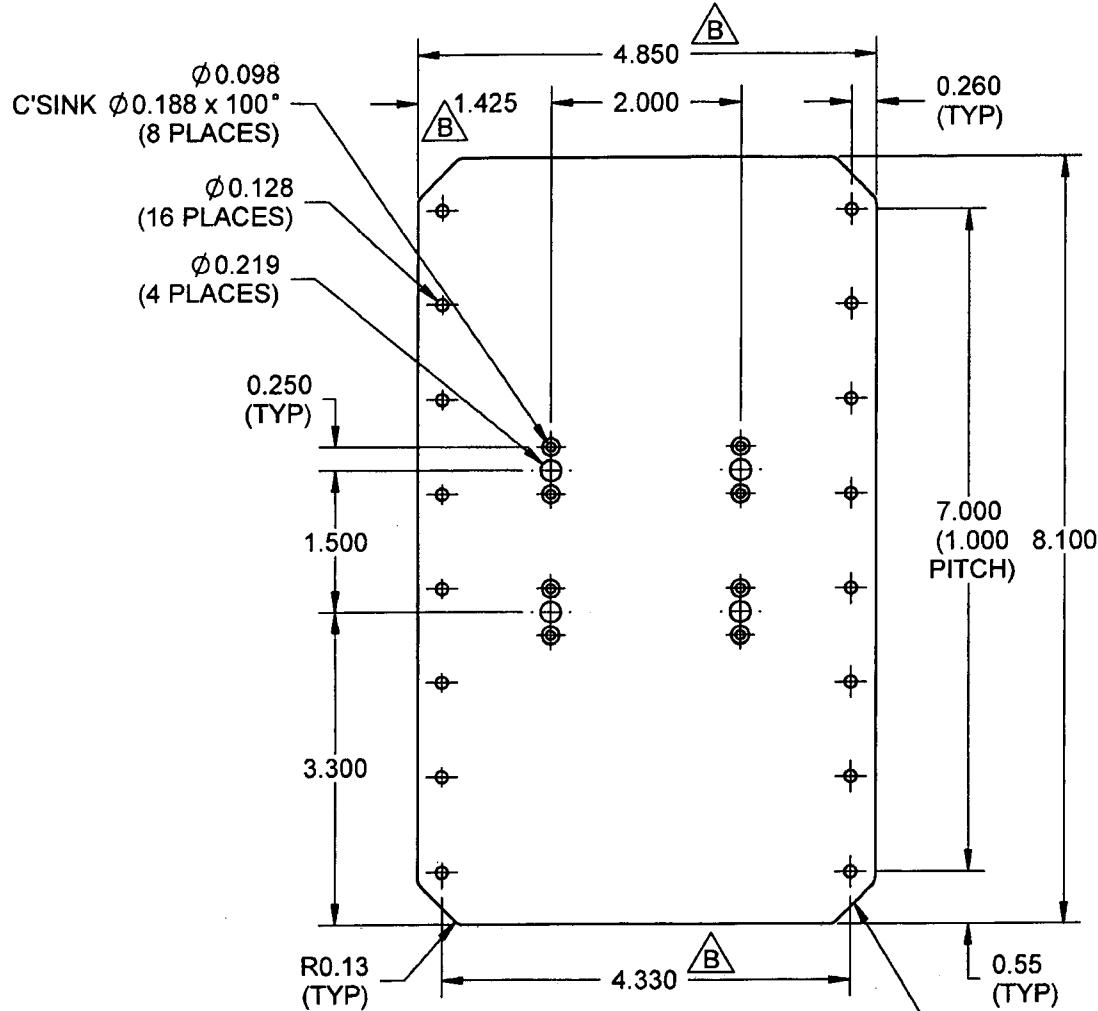
**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

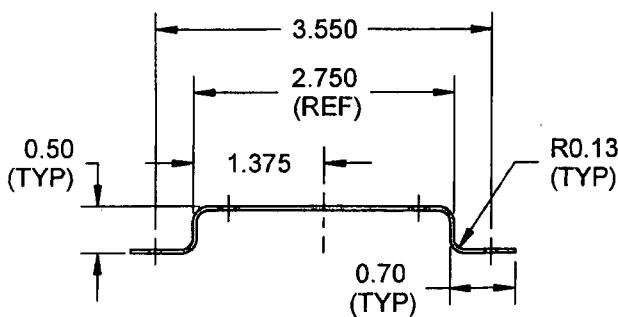
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CHECKED <i>PH</i>	APPROVED <i>HF</i>	DRAWING NO. D3303	
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	REV. B SHEET 4 OF 4



△ D3303-3F BRACKET FLAT PATTERN



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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